

April-25-14 11:38:30 AM

slp Monday 28/04
117563

Page 1

Item ID: D3870-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Mount, Fwd Upper

Stop *NS2*

Start Date: 4/25/14 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 4/28/14 **Req'd Qty:** 3.00

3

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D3870

0.00

100

FLOW WATER JET

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3870

Dwg Rev: A

Prog Rev: A

2- OPEN HOLE TO SIZE AS PER DWG

Deburr edges and holes if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

3 0 Jm14-04-28

3 0 Jm 14-04-28

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Quality Control

DAS
27
9-19

14/4/28

**DAS
30
9-89**

DAS
27

194120

3

3

3

—

3

~~_____~~

DGL 14-4-28

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Accept

Setup Start

NS1

Item Name: Mount, Fwd Upper

Stop

NS2

Start Qty: 3.00

3

Cust Item ID:**Req'd Qty: 3.00**

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Insp.
Stamp**

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

ship

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

3x DAS 28 APR 28 2014
9-89

MLJ 1404-28

(H) 14.4-28

Picklist Print

Page 1

April-25-14 11:38:30 AM

Work Order ID: 117563

117563

Parent Item: D3870-5

D3870-5

Parent Item Name: Mount, Fwd Upper

Start Date: 4/25/14

Required Date: 4/28/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No			100	f	14.5000	0.2	①			

M6061T6B0 250X04 000

**

Jm14-04-28

6061-T6 Bar .250 x 4.00

Location

Loc Qty

Loc Code

MAT051

14.5

124443

2.5

m127464

12

127464.

8

7

6

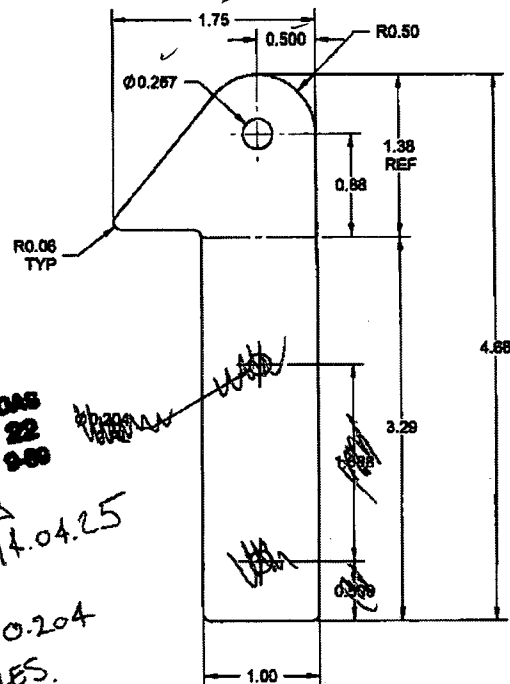
5

4

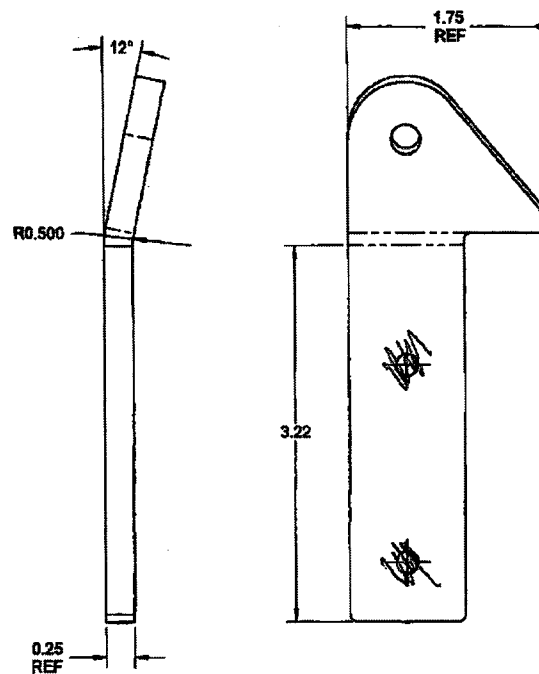
3

2

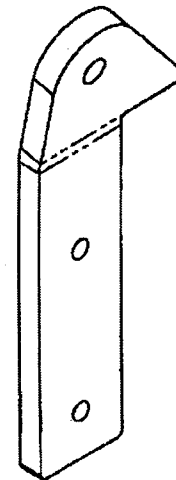
1



D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F



RELEASED
676/19 11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T69.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.12.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY REASON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

8

7

6

5

4

3

2

1

Linda Lacelle

From: Marc Bellavance
Sent: April-25-14 9:01 AM
To: David Duval; Linda Lacelle; Melanie Fauteux
Cc: Nigel Forbes
Subject: PAR14-342 - Bell Helicopter Textron
Attachments: PAR14-342.pdf; D3870-5_RevA_CUSTOM.dxf

All,

Please see attached PAR on which is recorded BHTPF's issue with positioning of D3870-5 Bracket. We have agreed to provide them with qty(3) blank no charge replacements. Our D3870-5 and our installation drawing will be updated accordingly on that same PAR.

I will be issuing a no charge PO for qty(3) D3870-5. Those must be custom made to attached 'D3870-5_RevA_CUSTOM.dxf'. Please provide me with the B/N for this part for the no charge PO. Also, please advise lead time.

Thanks,

Marc Bellavance
Technical Support

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M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



Technical Publications: Verify Revision Status/Download [HERE!](#)

Bon Route

[Handwritten signatures and scribbles]

